

### AMENDMENTS TO THE CLAIMS

This listing of claims replaces all prior versions, and listings, of claims in the application.

1. (Currently amended) A cast exhaust system for gas turbine or internal combustion engines comprising pressure-containing components comprising an air melted, substantially graphite and nitrogen-free cast steel comprising alloy of the following composition:

Carbon	0.2 to 0.4 wt.%
Silicon	0.5 to 6 wt.%
Manganese	0.1 to 1.5 wt.%
Phosphorous	0.01 to 0.08 wt.%
Nickel	34 to 36 wt.%
Chromium	2 to 3 wt.%
Sulphur	max 0.12 wt.%
Nitrogen	max 0.02 wt.%
Iron	<u>at least 50 wt.% balance.</u>

2. (Cancelled).

3. (Previously presented) The cast exhaust system of claim 1 further comprising maximum 1 wt.% of copper.

4. (Cancelled).

5. (Currently amended) The cast exhaust system of claim 1 further comprising:

Niobium	1 to 5 wt.%
Titanium	max 1 wt.%
Aluminum	max 1 wt.%,

6. (Currently amended) The cast exhaust system of claim 1 further comprising:

Niobium	max 2 wt. %
Tungsten	max 4 wt. %
Zirconium	max 1 wt. %
Vanadium	max 1 wt. %

7. (Currently amended) A process for the manufacturing of the cast exhaust system of claim 5, wherein said cast steel alloy is strengthened by precipitation hardening of  $(\text{Ni}_3[\text{Al}, \text{Ti}])$ ,  $(\text{Ni}_3[\text{Nb}, \text{Al}, \text{Ti}])$ , or  $(\text{Ni}_3\text{Nb})$ .

8. (Currently amended) A process for the manufacturing of the cast exhaust system of claim 1, wherein said cast steel alloy is strengthened by precipitation hardening of  $\text{Mo}_2\text{C}$ .

9. (Cancelled).

10. (Currently amended) The cast exhaust system of claim 1, wherein said cast steel alloy is aged by precipitation hardening.

11. (Currently amended) The cast exhaust system of claim 5, wherein said cast steel alloy is strengthened by precipitation hardening of  $\text{Ni}_3 [\text{Al}, \text{Ti}]$ ,  $\text{Ni}_3 [\text{Nb}, \text{Al}, \text{Ti}]$ , or  $\text{Ni}_3\text{Nb}$ .

12. (Currently amended) The cast exhaust system of claim 1, wherein said cast steel alloy is strengthened by precipitation hardening of  $\text{Mo}_2\text{C}$ .

13. (Currently amended) The cast exhaust system of claim 3, wherein said cast steel alloy is strengthened by precipitation hardening of  $\text{Mo}_2\text{C}$ .

14. (Currently amended) The cast exhaust system of claim 4, wherein said cast steel alloy is strengthened by precipitation hardening of  $\text{Mo}_2\text{C}$ .

15. (Currently amended) A process for the manufacturing of the cast exhaust system of claim 3, wherein said cast steel ~~alloy~~ is strengthened by precipitation hardening of  $\text{Mo}_2\text{C}$ .

16. (Currently amended) A process for the manufacturing of the cast exhaust system of claim 4, wherein said cast steel ~~alloy~~ is strengthened by precipitation hardening of  $\text{Mo}_2\text{C}$ .

17. (Previously presented) The cast exhaust system of claim 1 further comprising molybdenum in the range of 0.1 to 4 wt. %.